#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

### WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-000212 Address: 333 Burma Road **Date Inspected:** 04-Jun-2007

City: Oakland, CA 94607

OSM Arrival Time: 800 **Project Name:** SAS Superstructure **OSM Departure Time:** 1530 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No Wei Huang **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes N/A **Delayed / Cancelled:** No

34-0006 **Bridge No: Component:** HP200777-1

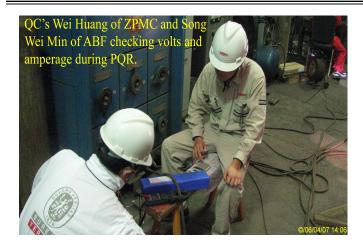
### **Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger continued witnessing ZPMC performing shield metal arc welding (SMAW) procedure qualification record (PQR) HP200777-1, PWPS-B-T-3213 test. The welder is identified as Mr. Zhu Hai Ping, welding passes fifty-two through sixty. The test plate material type is identified as A709 Grade HPS485W and thickness, 75 mm. The PQR complete joint penetration groove weld testing was performed in the vertical up (3G) position. The welding consumable is identified as a 4.0 mm electrode, classification E9018M MR, specification AWS A5.5. Caltrans QA observed ZPMC QA Inspector, Mr. Wei Huang and two associates monitoring and supervising the testing per AWS 5.13 criteria; amperages, voltages, travel speeds, preheat and inter-pass temperatures. Also present at the test site was American Bridge/Fluor (ABF) quality control (QC) inspector, Mr. Song Wei Min. QA observed that the wind velocity at the ZPMC testing site appear to be in conformance with AWS D1.5, paragraph 4.14.3 requirements. Welding was completed prior to the completion of the shift so final visual inspection will be carried out tomorrow morning. . For details see Welding Witness Report TL-6032 dated June 4, 2007. QA assigned Lot # B72-040-07 to this PQR.

# WELDING INSPECTION REPORT

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## **Summary of Conversations:**

No relevant conversations took place on this date.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer